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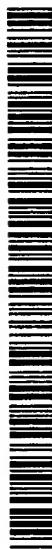
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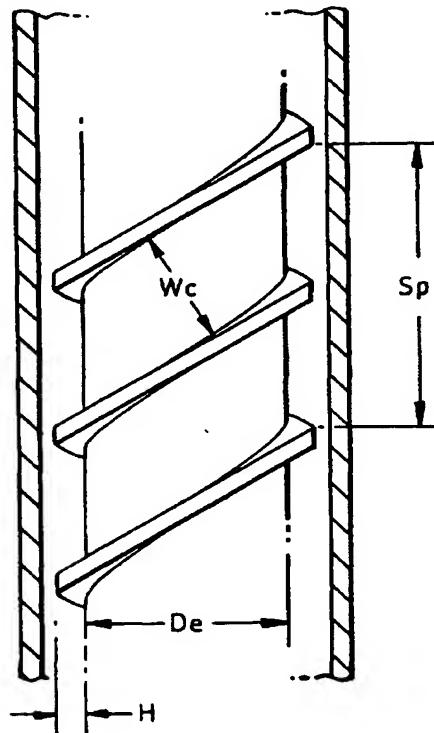
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[Continued on next page]

(54) Title: PROCESS AND APPARATUS FOR PRODUCTION OF A FROZEN FOOD PRODUCT



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(57) Abstract: The performance of an extruder when used in the manufacturing of ice cream by operating with a pitch angle of between 28 and 45 degrees with screws which have more than one thread start.



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- 1 -

Process and apparatus for production of a frozen food product

5 Technical field of the invention

The present invention relates to a process and an apparatus for the production of a frozen food product and more particularly an ice cream.

10

Background of the invention

Screw extruders such as single and twin screw extruders have been widely used and for a long time in the food 15 industry, for example in the production of cereal based products. More recently, it has also been proposed to use single or twin screw extruders in the freezing of ice cream.

EP713650 discloses a process and an apparatus for extruding 20 aerated frozen products wherein a twin screw extruder is used. The characteristic of the screws in the extruder is that they have a length over diameter ratio of between 30 and 60. It is not disclosed whether the diameter which is referred to is the diameter of the core of the screw or the 25 diameter of the core of the screw plus its pitch. EP0808577 discloses a similar process and apparatus but whilst uses a single screw extruder having the same geometry.

EP561118 discloses a process and an apparatus for 30 manufacturing frozen edible foams such as ice cream wherein a twin screw extruder is used. The geometry of the screw is defined by a (channel depth/channel width) ratio of approximately 0.1 and a pitch angle of between 22 and 30 degrees.

- 2 -

WO97/26800 discloses a process and an apparatus for manufacturing frozen edible foams such as ice cream wherein a single screw extruder is used. The geometry of the screw is defined by a (length of the screw/ inner diameter of the 5 extruder barrel) ratio of between 5 and 10 a (pitch/external screw diameter) ratio of 1 to 2 and a (external diameter of the screw/inner diameter of the screw) of 1.1 to 1.4. According to the drawings, the screw has a single thread start.

10

One of the big problems faced when using an extruder for the manufacture of ice cream is that a temperature as low as possible is required while keeping an acceptable flow. Now, the lower the temperature the bigger the flow resistance 15 which by generating frictions re-heats the product which is being cooled and limits the temperature which is thus achieved. There is therefore a need for optimising the geometry of the extruder in such a way that the increase in friction which is generated when the product is cooled is 20 minimised in order to reach a temperature as low as possible.

It has now been found that it is possible to dramatically increase the performance of an extruder when used in the 25 manufacturing of ice cream by;

- . operating with a pitch angle which is outside what has been used up to now in the manufacturing of ice cream,
- . operating with screws which have more than one thread 30 start whereas up to now screws with only one thread start screws have been disclosed,
- . operating with extruders which are much shorter than what has been used up to now.

- 3 -

Tests and Definitions

1. Screw parameters

5 An extruder screw is defined by different parameters which
need accurate definitions. In order to help in the
definition of such parameters, reference is made to Fig.1
which discloses a typical screw fitted in a single screw
extruder. Such an extruder is, for example, described in
10 Engineering principles of plasticating extrusion - Zehev
Tadmor - Krieger Publishing Company - 1978 - pages 39 to 45.

Screw length : LT (length of the screw which is in contact
with the barrel)

15 Pitch length: Sp (axial distance of a full turn (screw
lead))

Thread starts: A screw can have more than one helix, in the
20 rest of the description, each helix is called a thread start
and the number of thread starts is 'n'. On Fig.1, the screw
which is represented has two thread starts.

25 Channel depth: H (the distance between the root of the screw
and the inner surface of the barrel less the radial
clearance between the crest of the screw and the inner
surface of the barrel)

30 Screw diameter De: Diameter of the barrel less the distance
between the root of the screw and the inner surface of the
barrel.

Pitch angle: $\text{Arctg}(\text{Sp}/\pi \cdot \text{De})$

- 4 -

Channel width: w_c (distance between the flights along a helical line which is perpendicular to the flight).

Summary of the invention

5

It is a first object of the present invention to provide an extruder comprising an extruding screw characterised by between 2 and 6 thread starts, preferably 2 and 5 thread starts, and a pitch angle of between 28 and 45 degrees,
10 preferably between 32 and 42 degrees.

Preferably the extruder comprises cooling means, more preferably, the cooling means are constituted by a cooling circuit wherein a cooling liquid is circulated. Even more
15 preferably the cooling liquid is ammonia or nitrogen.

It has been found that the higher the number of thread starts, the higher the ammonia temperature required to achieve a given temperature at the output of the extruder,
20 showing that increasing the number of thread starts leads to a better cooling effect.

Preferably the (H/w_c) ratio is between is less than 0.2, more preferably more than 0.1. It has been found that at low
25 H/w_c ratio, the heat exchange (cooling) improves but the thermal dissipation (heating) due to friction increases. Conversely at higher H/w_c ratio, the heat exchange decreases but the thermal dissipation decreases even more, therefore, operating at high H/w_c ratio is preferred. There is nevertheless a limit in the H/w_c ratio which can be used
30 since, above a certain limit, the product is no longer thermally homogeneous and cold and warm zones start appearing which do not mix any more.

- 5 -

Preferably also, the screw comprises between 3 and 4 thread starts and the cooling liquid is ammonia.

Preferably also the screw has a LT/De ratio of between 2 and 5, more preferably between 2 and 5, even more preferably between 2 and 4. It has been found that, and contrary to what is suggested by the prior art, not only there is no need for going for long screws but it is effectively a waste of energy. If the screw is too long, the heat dissipation due to the friction caused by the increase in viscosity generated by the cooling tends to equate the cooling effect and the two phenomenon (cooling and heat dissipation) equilibrate and there is no cooling taking place at the end of the screw. Nevertheless, the friction existing at the end of the screw, where no cooling takes place, requires additional torque to keep the screw rotating for no benefit to the process or the end product.

Preferably also, the extruder is a single screw extruder.

It is a second object of the invention to provide extruder comprising an extruding screw characterised by a pitch angle of between 28 and 45 degree, preferably between 32 and 42, and a LT/De ratio of between 2 and 10, preferably 2 and 5, more preferably 2 and 4.

It is a third object of the present invention to provide a process for the manufacturing of frozen food product, wherein a food composition is mixed, aerated and cooled down to a temperature of between -4°C and -7°C and then processed in an extruder for further cooling down to a temperature of between -12° and -20°, characterised in that the extruder comprises an extruding screw having 2 to 5 thread starts and a pitch angle of between 28 and 45 degrees, preferably between 32 and 42 degrees, and further comprises cooling

- 6 -

means, the cooling means being preferably constituted by a cooling circuit wherein a cooling liquid is circulated.

Preferably the cooling liquid is selected within the group
5 consisting of ammonia or nitrogen. More preferably, the screw comprises between 3 and 4 thread starts and the cooling liquid is ammonia.

Preferably also the screw has a LT/De ratio of between 2 and
10 10, more preferably between 2 and 5, even more preferably between 2 and 4.

Preferably also, the extruder is a single screw extruder.

15 It is a fourth object of the invention to provide a process for the manufacturing of frozen food product, wherein a food composition is mixed, aerated and cooled down to a temperature of between -4° and -7° and then processed in an extruder for further cooling down to a temperature of
20 between -12° and -20°, characterised in that the extruder comprises cooling means, the cooling means being preferably constituted by a cooling circuit wherein a cooling liquid is circulated and further comprises an extruding screw having a pitch angle of between 28 and 45 degrees, preferably between
25 32 and 42 degrees, and a LT/De ratio of between 2 and 10, preferably between 2 and 5, more preferably between 2 and 4.

Preferably the cooling liquid is selected within the group
30 consisting of ammonia or nitrogen. Preferably also the screw comprises between 3 and 4 thread starts and the cooling liquid is ammonia.

- 7 -

Detailed description of the invention

The present invention will be further described in the following examples and by reference to the drawing wherein;

5

- . Figure 1 represents a schematic view of an extruder comprising an extruding screw.

An ice cream premix having the following composition;

10 Total fat: 8.4%

Stabiliser emulsifier: 0.56%

Added Sugars: 16.8%

Total protein : 3.5%

Total solids: 34.9%

15 Of which Milk solids (non fat): 9.55%

Water: the rest

was aerated up to an overrun of 100% and cooled down to a

temperature of -4.5°C using conventional means for subsequent

20 processing.

The cooled product obtained was then conveyed to a single screw extruder according to the invention for subsequent extrusion. The product was extruded at 500 litre ice cream

25 per hour in a single screw extruder cooled with ammonia, the screw having a diameter of 200mm.

Various screw geometries were tested and the results are summarised in the following table.

Pitch angle (degree)	Channel depth (H) (mm)	Number of Thread Starts	H/WC	Ice cream temperature (°C)	Torque (Nm)	Ammonia temperature (°C)	Rotation speed (rpm)	Extruder Inlet Pressure (bar)
12	15	2	0.28	-11.6	1572	-30.8	29.0	8
14	17	3	0.43	-11.6	1486	-30.5	30.2	8
19	10	4	0.25	-12.1	1597	-27.2	22.6	8
28	8	4	0.12	-11.9	1629	-27.5	18.8	8
35	8	4	0.10	-12.9	1602	-25.9	14.6	8
40	11	4	0.12	-14.1	1600	-26.8	12.4	8
40	5	6	0.09	-12.2	1609	-25.0	21.0	10.
40	7	6	0.12	-12.7	1604	-26.1	20.6	10
40	9.8	6	0.17	-13.7	1602	-26.2	13.2	10
40	11	6	0.19	-13.1	1600	-26.1	12.4	10
40	11	3	0.09	-13.6	1601	-28.2	12.1	10
40	15.5	3	0.12	-13.4	1597	-28.0	10.4	10
40	18	3	0.14	-13.8	1602	-27.6	9.7	10

Claims

1. Extruder comprising an extruding screw, said extruding screw being characterised by between 2 and 6 thread starts and a pitch angle of between 28 and 45 degrees, preferably between 32 and 42 degrees.
5
2. Extruder according to claim 1 comprising cooling means, the cooling means being preferably constituted by a cooling circuit wherein a cooling liquid is circulated.
10
3. Extruder according to claim 2 wherein cooling liquid is selected within the group consisting of ammonia or
15 nitrogen.
4. Extruder according to claim 3 wherein the screw comprises between 3 and 4 thread starts and the cooling liquid is ammonia.
20
5. Extruder according to claim 1 wherein the screw LT/De ratio of between 2 and 10, preferably between 2 and 5, more preferably between 2 and 4.
- 25 6. Extruder according to claim 1 wherein the H/wc ratio is under 0.2, preferably over 0.1.
7. Extruder according to any preceding claim wherein the extruder is a single screw extruder.
30
8. Extruder comprising an extruding screw characterised by a pitch angle of between 28 and 45 degrees, preferably 32 and 42 degrees, and a LT/De ratio of between 2 and 10, preferably between 2 and 5, more preferably between 2 and 4.
35

- 10 -

9. Extruder according to claim 8 comprising cooling means, the cooling means being preferably constituted by a cooling circuit wherein a cooling liquid is circulated.

5 10. Extruder according to claim 9 wherein the cooling liquid is selected within the group consisting of ammonia or nitrogen.

10 11. Extruder according to claim 10 wherein the screw comprises between 3 and 4 thread starts and the cooling liquid is ammonia.

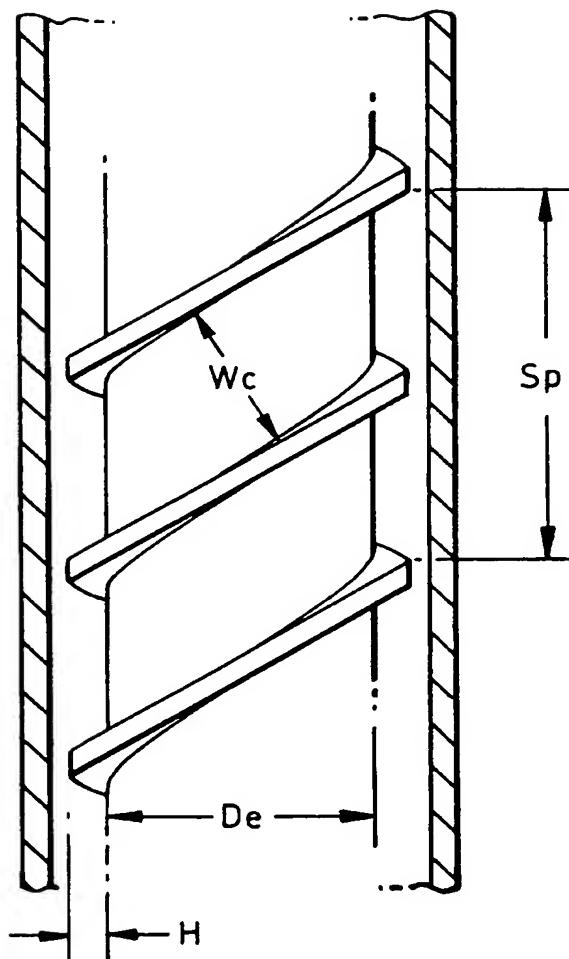
12. Extruder according to any preceding claim 8 to 11 wherein the extruder is a single screw extruder.

15 13. Process for the manufacturing of frozen food product, wherein a food composition is mixed, aerated and cooled down to a temperature of between -4° and -7° and then processed in an extruder for further cooling down to a 20 temperature of between -12° and -20°, characterised in that the extruder comprises cooling means, the cooling means being preferably constituted by a cooling circuit wherein a cooling liquid is circulated and further comprises an extruding screw having a pitch angle of 25 between 28 and 45 degrees, preferably between 32 and 42 degrees

30 14. Process according to claim 13 wherein the screw has a LT/De ratio of between 2 and 10, preferably between 2 and 5, more preferably between 2 and 4.

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Fig. 1.



INTERNATIONAL SEARCH REPORT

International Application No
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A. CLASSIFICATION OF SUBJECT MATTER			
IPC 7	A23G9/16	A23G9/04	A23G9/22
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According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)
IPC 7 A23G B29C A23P

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

EPO-Internal, WPI Data, PAJ

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
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		-/-

Further documents are listed in the continuation of box C.

Patent family members are listed in annex.

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INTERNATIONAL SEARCH REPORT

International Application No PCT/EP 00/04724

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